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D3729-1

Job Sheet 190338



Part No: D3729-1

Job Qty: 10 pcs

Part Name: Step Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/7/19

Job Tracking No:

Due Date: 2/25/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 08-01-30 new issue DD verified by:EC IPP Rev:B 08-02-26 ECN 1140p DD verified by: IPP Rev:C 08-03-19 ecn 1158 DD verified by:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1 <i>Omax</i>	10 pcs		2/25/19	0.00	9.41	Waterjet - Flow		<i>ae 19/02/22</i>
120	QC 8	10 pcs		2/25/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		<i>DAS</i>
							QC 8 - 9		<i>40</i>
							QC 8 - 68		<i>989</i>
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
130	Small Fab - 2 - B4B	10 pcs		2/25/19	0.00	0.00	Small Fab - 1 - B4B		
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		<i>DAS</i>
							Small Fab - 4 - B4B		<i>36</i>
							Small Fab - 5 - B4B		<i>9-80</i>
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
140	QC 5	10		2/25/19	0.00	0.00	QC 5 - 10		

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	pcs				QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS
					QC 5 - 9	40
					QC 5 - 50	9:39
					QC 5 - 30	9:39
150 Handfinish - 1-1 Chemical-B4B	10 pcs	2/25/19	0.00 5.13	Handfinish - 1 - 1 - B4B		
				Handfinish - 1 - 2 - B4B		
				Handfinish - 1 - 3 - B4B		
				Handfinish - 1 - 4 - B4B		
				Handfinish - 1 - 5 - B4B		
				Handfinish - 1 - 6 - B4B		
				Handfinish - 1 - 7 - B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		D.R 19/03/07
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
160 QC 3	10 pcs	2/25/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 26		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
			</			

					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 6	DAS
					QC 3 - 68	40
					QC 3 - 9	9-89
						MAR 07 2019
170	Packaging 3-1 - Stock - B4B	10 pcs	2/25/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	WA 003 DP MAR 11 2019
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
180	QC 21 - SA	10 pcs	2/25/19	0.00 0.00	QC 21 - SA - 21	DAS
					QC 21 - SA - 70	MAR 13 2019 70
					QC 21 - SA - 53	9-89

Part Op 100 - 1-Cut as per Dwg D3729 Dwg Rev: B Prog Rev: B 2- Deburr if necessary
 Descriptions: 120 - (QC8- Inspect parts - second check)
 130 - (Small Fab) 1- open holes to finish size as per dwg D3729 2- Deburr if necessary 3- grind water jet marks all around bracket smooth ****do not grind inside where step extrusion goes****
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC3- Inspect Part Finish)
 170 - (Identify as per dwg & Stock Location: _____)
 180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.500X05.000	6061-T6 Bar .500 X 5.00	9.5830 ft (.9583 ea)	100-Waterjet - Flow - 1	5033404

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6B0.500X05.000	10	16	0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type Special Comments
1	Step Bracket	4.380inches ± 0.030	4.410 4.350	Product 4.355
2	Step Bracket	11.500inches ± 0.030	11.530 11.470	11.50
3	Step Bracket	3.500inches ± 0.030	3.530 3.470	3.50
4	Step Bracket	0.750inches ± 0.030	0.780 0.720	0.760
5	Step Bracket	2.520inches $+ 0.010$ $- 0.000$	2.530 2.520	2.520
6	Step Bracket	1.400inches ± 0.030	1.430 1.370	1.426
7	Step Bracket	0.257inches $+ 0.006$ $- 0.001$	0.263 0.256	0.257
8	Step Bracket	0.159inches $+ 0.005$ $- 0.001$	0.164 0.158	0.159
9	Step Bracket	0.625inches ± 0.010	0.635 0.615	0.626
10	Step Bracket	0.625inches ± 0.010	0.635 0.615	0.623
11	Step Bracket	1.250inches ± 0.010	1.260 1.240	1.249
12	Step Bracket	0.440inches ± 0.010	0.450 0.430	0.430
13	Step Bracket	0.576inches ± 0.010	0.586 0.566	0.579
14	Step Bracket	2.000inches ± 0.010	2.010 1.990	2.002
15	Step Bracket	1.000inches ± 0.010	1.010 0.990	1.001
16	Step Bracket	0.500inches ± 0.010	0.510 0.490	0.501
17	Step Bracket	0.675inches ± 0.010	0.685 0.665	0.665

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

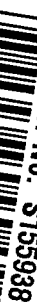
Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S155938



Part: D3729-1

Job No: 190338

Serial No/Batch: S155938

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/23/19